



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE105-40001W1-3
Job Sheet 171957-A



Part No: RBE105-40001W1-3

Job Qty: 3 ea

Part Name: Base



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/22/18

Job Tracking No:

Due Date: 4/23/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG RBE105-40001W1 Rev 1 IPP Rev A 18.02.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	QC	3 pcs		4/23/18	0.00	0.00	QC2 Machining-4		
130	QC	3 pcs		4/23/18	0.00	0.00	QC8 Machining-4		
140	Packaging	3 pcs		4/23/18	0.00	0.00	Packaging3-1		
150	QC21-SA	3 Ea		4/23/18	0.00	0.00	QC21		

Handwritten notes:
18/05/23
DAS 21
9-80
G-A 134

Job BOM

Job BOM records could not be found.

Handwritten: MAY 23 2018

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 5/22/18 10:17 AM dart.leroux.jason



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RBE105-40001W1-3
Job Sheet 171957



Part No: RBE105-40001W1-3

Job Qty: 1 ea

Part Name: Base



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/9/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-40001W1 Rev 1 IPP Rev A 18.02.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/15/18	0.00	0.00	Start Up Machining-2		
110	Mori Seiki	4 pcs		2/16/18	0.00	2.00	MORI SL2500Y		
120	QC	4 pcs		2/16/18	0.00	0.00	QC2 Machining-4		
130	QC	4 pcs		2/16/18	0.00	0.00	QC8 Machining-4		
140	Packaging	4 pcs		2/16/18	0.00	0.00	Packaging3-1		
150	QC21-SA	4 Ea		2/16/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per folio FB 908 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 3-Engrave T/N and/or P/N number using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R2.500	17-4 SS Round Bar (H900 Condition)	.4800 ft (.12 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R2.500	0	0	0

Part Specifications

Specifications could not be found.

Plex 2/9/18 12:38 PM Dart.lajeunesse.marie



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S057094



Part: RBE105-40001W1-3

Job No: 171957

Serial No/Batch: S057094

Revision: 1

Inspector:

Date: 03/31/18

DART AEROSPACE LTD		Work Order: 171957
Description: Base		Part Number:
Inspection Dwg: RRE105-4001W1-3	Rev: 1	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.1555/.1560	—	.1555	✓		gauge Pin	
Ø.32	±.01	.318	✓		SL10	Vern
Ø1.81	±.01	1.807	✓		Vern LPO8	
Ø2.48	±.01	2.475	✓		↓	
1.25	±.005	1.255	✓		↓	
.118	±.005	.116	✓		SL10	Vern
.38	±.01	.385	✓		Vern LPO8	
.475	±.005	.478	✓		↓	
30°	±.5°	30°	✓		"	
.05x45°	±.01 x .5°	.05x45°	✓		Vern LPO8	
M14x1.5-6H	GO-NOGO	M14x1.5	✓		thread gauge	
.50	±.01	.498	✓		SL10	Vern
Ø.59x90°	±.01 x .5°	.589	✓		"	
M5x.8-6H	GO/NOGO	M5x.8	✓		Thread gauge	
.3141/.3150	—	.3145	✓		gauge Pin	
.71	±.01	.708	✓		SL10	Vern
M50x1.5-6G		M50x1.5	✓		"	
Maj Ø1.9626	±.0047	1.959	✓		MIC LPO3	
WØ.040		.040	✓		↓	
DOW 1.9946	±.0032	1.993	✓		↓	
.1555	±.01 / ±.000	.1555	✓		SL10	Vern
Ø.32						

Measured by: P / J.J.	Checked by: [Signature]	QC Inspector:
Date: 18-03-31 / 18-05-20	Date: 18/05/23	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

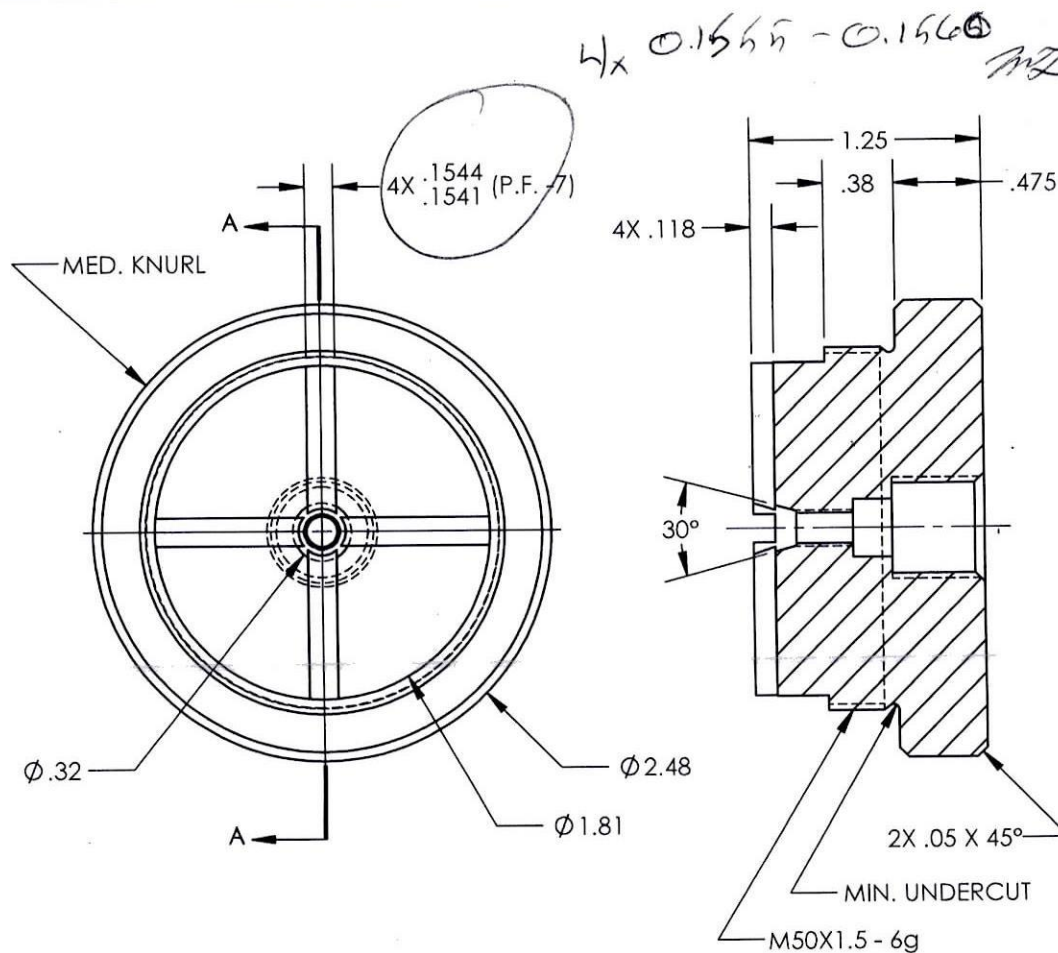
QA Closed: _____ Date: _____

Work Order update only ☐

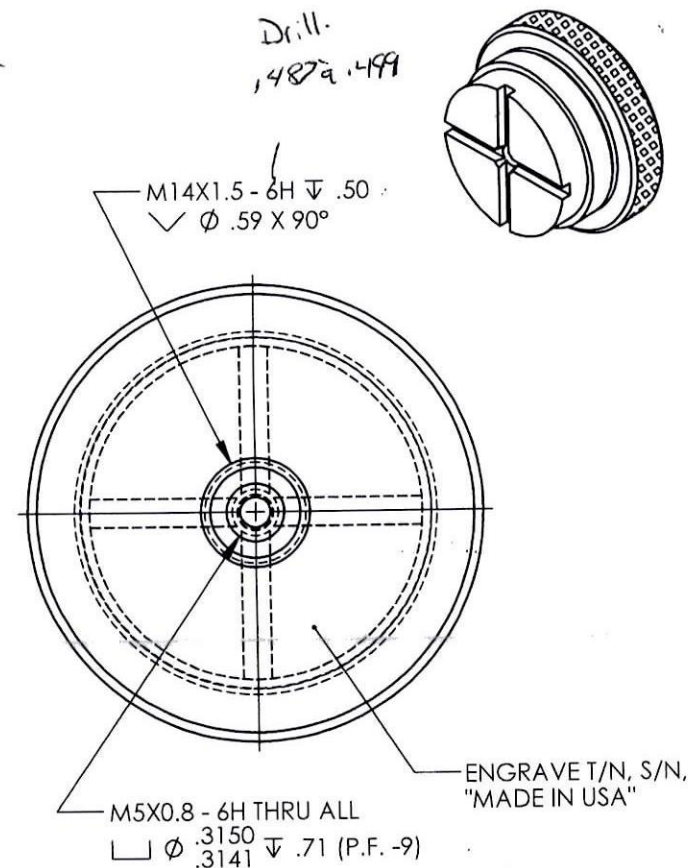
Work Order: <u>171957</u> Part No. <u>RBE101-40001W1-3/-5/-9</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																															
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Description Work Order Deviation				Disposition																																																																																																																																			
- RBE101-40001W1-3/-5 can be manufactured from 17-4PH-H900 as an alternative material - Heat treat is no longer applicable - Zinc plate is no longer applicable - RBE101-40001W1-9 material call-out is vague, manufacture from M-Delrin-R or MT-Nylon 6-R. - KEYWAY TOLERANCE SH MUST BE 0.1555"-0.1565" (LIGHT PRESS FIT)				- This deviation is acceptable. - The drawings will be updated to reflect these changes. - The fit, form and function of the tool will be as originally intended.				Completed By																																																																																																																															
								Lead hand / Supervisor Approval Verification																																																																																																																															
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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			



SECTION A-A



(-3)

BASE

DART AEROSPACE	
TITLE STAKING TOOL RETAINER	
DWG NO. RBE105-40001W1-3	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT RC 45-50	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
TREAT ZINC PLATE	.XX $\pm$.01 ANGLES $\pm$ 5°
FINISH	.X $\pm$.1 SURFACES = 125 ✓
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	SEE SHEET 1 NOTE 2
APPROVED: GILBERT	
SCALE 1:1	DATE 1/19/2016
SHEET 3 OF 6	